

Work Order ID 61640

August 31, 2010 7:08:41 AM

Page 1

Item ID: D3537-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearpad

Start Date: 8/31/10 Start Qty: 100.00

Cust Item ID:

Required Date: 9/03/10 Req'd Qty: 100.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev: C 1 Prog Rev: C 1 2-Deburr if necessary

304 .063

10-8-31

(120)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-8-31

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/31/10

10-8-31

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Cust Item ID:

Required Date: 9/03/10 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00				(120)			
Brake NC	Memo	0.00							
Brake NC	1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1								
140 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch A/R 2059B Hardcoat								
	M 11553 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary								
150 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									

SB 10/08/01

ER 10-9-9 (120)

counts
(120)

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Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5 10/09/09

Memo

0.00

count
x120

170



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

BL 10-9-10

M 112588

Memo

0.00

START TIME:

10:00

OVEN TEMPERATURE:

320° FINISH TIME:

10:30

120

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

M 10/09/13

Memo

0.00

x120 d

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Start Qty: 100.00



Cust Item ID:

Required Date: 9/03/10

Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location:

FP-17

0.00

PL 10-9-13

120



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/14 HJ

PL 10-9-13
120

Picklist Print

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Page 1

Work Order ID: 61640

Parent Item: D3537-1

Parent Item Name: Wearpad



Start Date: 8/31/10

Required Date: 9/03/10

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

82.9000

0.106

11.15789

12.8



B 10-8-31

304/316 Sheet.063

Location

Loc Qty

Loc Code

MAT20

82.9

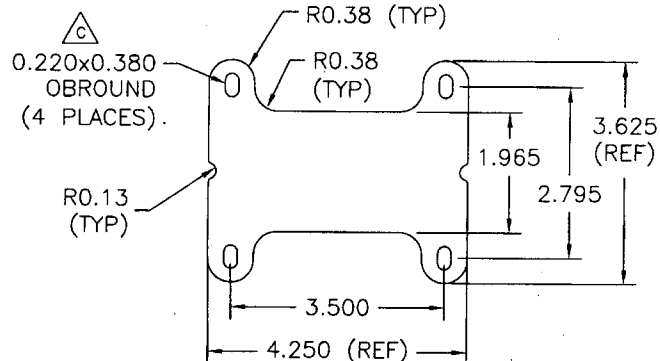
115440

82.9

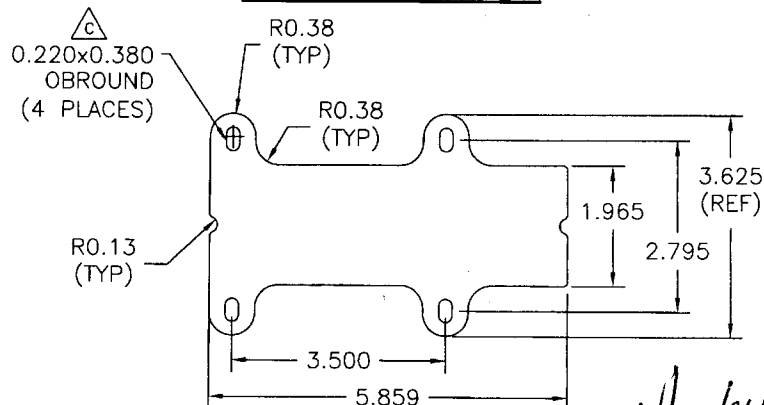
115440

120

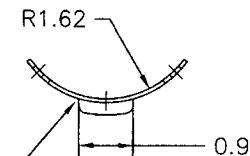
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

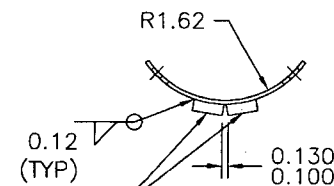


SECTION A-A



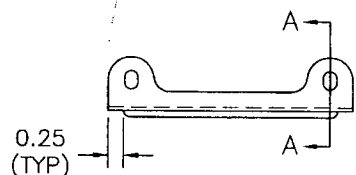
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B

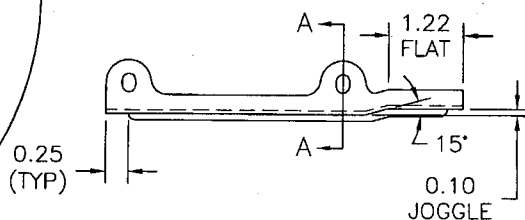


D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

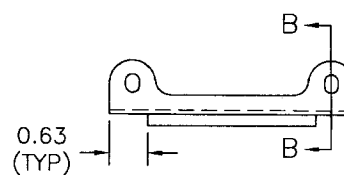
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



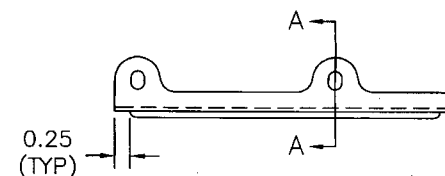
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	A	APPROVED A
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET 1 OF 1		SCALE 1:2

RELEASED
07.05.08 P.H.
PER ECU
962